

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017571**Date Inspected:** 05-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of weld joints BK004A6-021-023, 035 located on PCMK BK004A6-021. Welder was identified as 202319. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bin Bin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2114.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW tack welding of weld joints BK004A8-025-041~044 located on PCMK BK004A8-025. Welder was identified as 057242. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Jun (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2112 and WPS-B-P-2113.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

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ABF representatives performing ultrasonic testing of the bottom plate to side plate holdback weld joints on either side of the 10BE/10CE transverse weld joint.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers' lift 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East, south, west, and north towers, lift 4 were positioned on top of east, south, west, and north towers, lift 3, respectively, on the Heavy Dock. ZPMC workers were match drilling 33mm holes, using magnetically attached drill presses, through previously drilled holes in outer strut top flanges, into connection plates at south and west towers, 131M level, skin A. The ZPMC 1300 ton floating crane was moored to the Heavy Dock and sitting idle.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
